

Process Sheet

*(Signature)* 08/12/08

Customer	: CC-DAR01 Dart Aerospace Ltd.		Drawing Name	: D3630-041	
Job Number	: 44113 <i>AP</i>		Part Number	: REWORK20 <i>D3630-041</i>	
Estimate Number	: 10804		Drawing Number	: NCR08-122	
P.O. Number	:		Project Number	:	
This Issue	: 16/12/2008 S.O. No. :		Drawing Revision	:	
Prsht Rev.	: NC		Material	:	
First Issue	: / / Type : SMALL / MED FAB		Due Date	: 23/12/2008 Qty: 1 Um: Each	
Previous Run	: 00015				
Written By	:				
Checked & Approved By	: <i>JUL 08.12.16</i>				
Comment	:				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D3630041	Cyclic Stick
<p>Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Cyclic Stick</p> <p>Remove from stock: Qty: <i>1</i> B <i>37120</i> <i>08.12.16</i> ①</p> <p>Qty: _____ B _____ Qty: _____ B _____</p>		
2.0	QC5	INSPECT WORK TO CURRENT STEP
<p>Comment: INSPECT WORK TO CURRENT STEP Ensure all dimensions are as per the drawing.</p> <p><i>08.12.16</i> ①</p>		
3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
<p>Comment: LARGE FABRICATION RESOURCE 1 Fill the affected 0.189" holes with weld on the D3630-1 Grind flush, and ensure there is no weld on the inside wall of the tubing.</p> <p><i>08.12.16</i> ①</p>		
4.0	QC10	VISUAL INSPECTION OF GROUND WELDS
<p>Comment: VISUAL INSPECTION OF GROUND WELDS</p> <p><i>08.12.16</i> ①</p>		
5.0	SMALL FAB 1.	SMALL & MEDIUM FAB RESOURCE 1
<p>Comment: SMALL &amp; MEDIUM FAB RESOURCE 1 Drill the 0.189" hole as per dwg on the D3630-1. Debur inside and out.</p> <p><i>08.12.16</i> ①</p>		

## Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D3630-041

Job Number: 44113

Part Number: REWORK20

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



10/8/12/17 ①



Comment: INSPECT WORK TO CURRENT STEP

Ensure all other dimensions are as per the drawing.

7.0 PACKAGING 1

PACKAGING RESOURCE #1



10/8/12/17 ①



Comment: PACKAGING RESOURCE #1

Identify the parts with the new batch # and return to stock.

Location: \_\_\_\_\_

8.0 QC21

FINAL INSPECTION/W/O RELEASE



08/12/17 ①

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MR 08-12-17

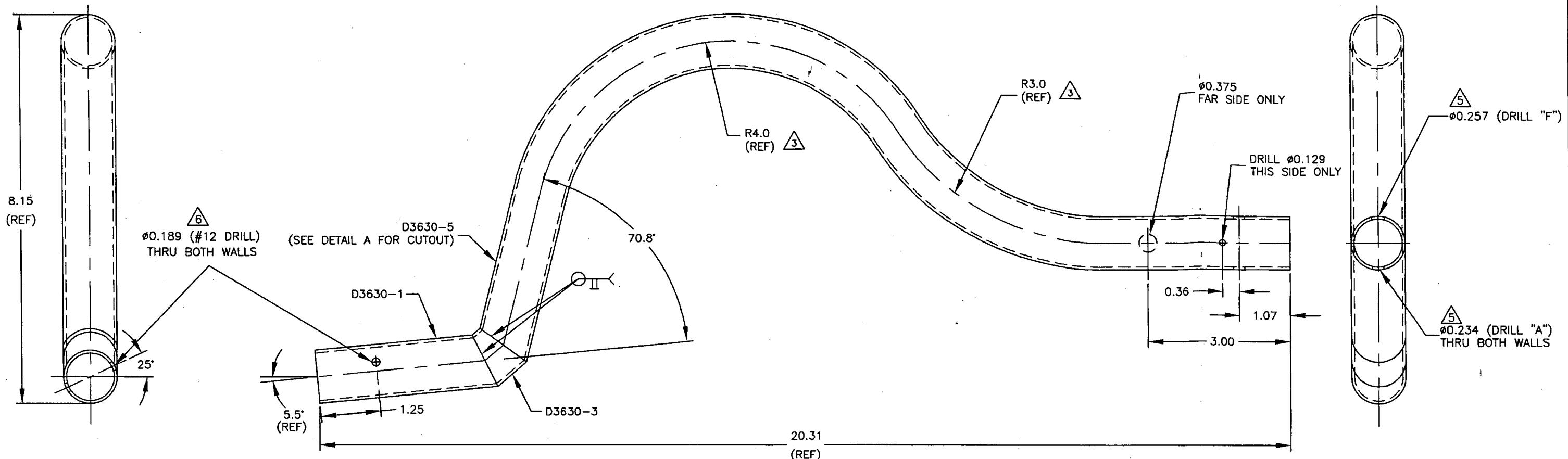
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

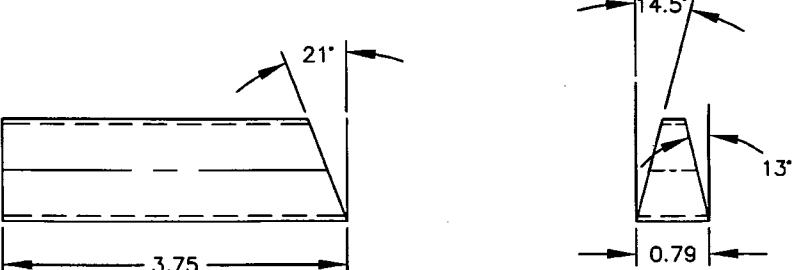
NOTE: Date & initial all entries



### D3630-041 CYCLIC STICK

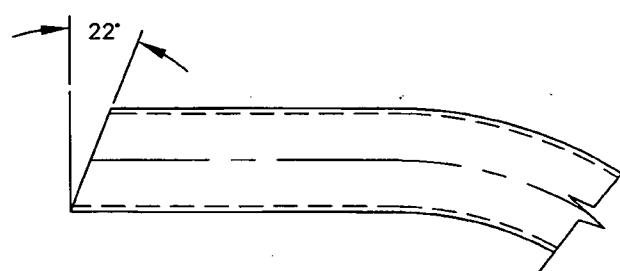
(REPLACES GENEVA P/N G10202)

RELEASED  
07.11.29



**D3630-1**  
(REPLACES GENEVA P/N G10202-1)

**D3630-3**  
(REPLACES GENEVA P/N G10202-2)



**D3630-5**  
(REPLACES GENEVA P/N G10202-3)

DETAIL A: CUTOUT

#### NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING 1.125" OD X 0.065" WALL (REF. DART SPEC M304TR1.125W.065)
- 2) FINISH: NONE
- 3) REFER TO TEMPLATE DT8940
- 4) WELD PER DART QSI 004
- 5) DRILL Ø0.234 THRU BOTH WALLS THEN DRILL Ø0.257 THRU ONE WALL AS SHOWN
- 6) DRILL Ø0.189 THRU BOTH WALLS AT 25° OFF HORIZONTAL AXIS AS SHOWN
- 7) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 8) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 9) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 10) IDENTIFY WITH DART P/N "D3630-041" USING FINE POINT PERMANENT INK MARKER

#### PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3630-041	CYCLIC STICK
1	D3630-1	TUBE
1	D3630-3	TUBE
1	D3630-5	TUBE

RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO 44113

A	07.05.11	NEW ISSUE: REPLACES G10202
DESIGN CLB	DRAWN BY SC	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED B	APPROVED H	DRAWING NO. D3630
DATE 07.05.11	SCALE 1:2	SHEET 1 OF 1 TITLE CYCLIC STICK

COPYRIGHT © 2007 BY DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL  
AND IS SUPPLIED ON THE EXPRESS CONDITION  
THAT IT IS NOT TO BE USED FOR ANY PURPOSE  
OR COPIED OR COMMUNICATED TO ANY OTHER  
PERSON WITHOUT WRITTEN PERMISSION FROM  
DART AEROSPACE USA, INC.

REV. A

SHEET 1 OF 1

1:2